

# Work Order ID 80931

**\*80931\***

Page 1

Monday, March 05, 2012 12:56:02 PM

Item ID: D6102-013

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle Billet

Start Date: 3/5/2012 Start Qty: 24.00

**\*24\***

Cust Item ID:

Required Date: 3/12/2012 Req'd Qty: 24.00

**\*24\***

Customer:

Reference:

Run Start **\*NR1\***

Approvals:

Process Plan:

Date: 12-03-5

Tooling:

Date:

Stop **\*NR2\***

QC:

Date:

SPC (Y/N):

Date:

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
| D6102    | Rev D        |

100

0.00

**\*100\***

Purchasing

PURCHASING

Memo

0.00

Purchasing

Issue P/O: 14358 a) Description: Aluminum Billetb) 7.000" x 6.500" x 2.000" thickc) Tolerance on all dimensions is +0.06/0.00d) Grain direction along 6.500" lengthe) Material: 6061-T6/T6511 (QQ-A-250/11 or QQ-A-200/8)Material release certifi

12-03-6

110

Receive & Inspect for Damage & Mat'l Certs

0.00

**\*110\***

Packaging

Memo

0.00

Packaging

Ensure material certification is attached

12/3/10 (24)

120

QC6- Inspect dimensions to drawing

0.00

**\*120\***

QC

Memo

0.00

Quality Control

Check certification to Dwg D6102 for compliance

12/03/19 24

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

# Work Order ID 80931

**\*80931\***

Page 2

Monday, March 05, 2012 12:56:02 PM

Item ID: D6102-013 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Saddle Billet  
 Start Date: 3/5/2012 Start Qty: 24.00 **\*24\*** Cust Item ID:  
 Required Date: 3/12/2012 Req'd Qty: 24.00 **\*24\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                           | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 130                            | Identify as per dwg & Stock Location: <u>MAF44</u> | 0.00                 |         |        |              |               |               |                  |                |
| <b>*130*</b>                   |  |                      |         |        |              |               |               |                  |                |
| Packaging                      | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Packaging                      |  |                      |         |        |              |               |               |                  |                |
| 140                            | QC21- Final Inspection - Work Order Release        | 0.00                 |         |        |              |               |               |                  |                |
| <b>*140*</b>                   |  |                      |         |        |              |               |               |                  |                |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |  |                      |         |        |              |               |               |                  |                |

*ml 12/03/19*

*24*

*MLJ 12/03/19*

*MLJ 12-03-19*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Picklist Print**

Page 1

Monday, March 05, 2012 12:56:31 PM

Work Order ID: 80931

**\*80931\***

Parent Item: D6102-013

**\*D6102-013\***

Parent Item Name: Saddle Billet

Start Date: 3/5/2012

Required Date: 3/12/2012

Start Qty: 24.00

Required Qty: 24.00

Comments: IPP Rev:A New Issue 06-07-03 JLM

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D6102-013P

Purchased

No

110

Each

0.0000

1

24

**\*D6102-013P\***

6061-T6 7.0x6.5x2.0

**\*\***012/3/10 (27)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

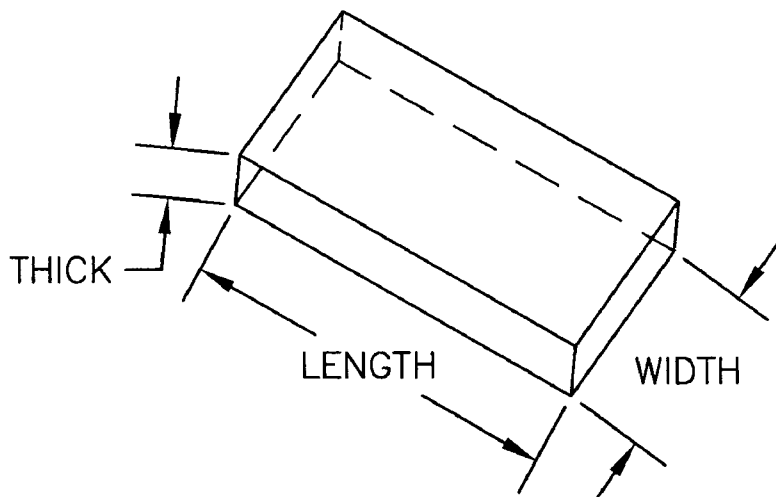
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



|                  |                |   |                        |
|------------------|----------------|---|------------------------|
| DESIGN<br>#      | DRAWN BY<br>PH | <b>DART AEROSPACE LTD.</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br>CP    | APPROVED<br>#  | DRAWING NO.<br>D6102                                      | Reg. D<br>SHEET 1 OF 1 |
| DATE<br>06.06.30 |                | TITLE<br>SADDLE BILLET, 6061                              | SCALE<br>NTS           |
| A                | 01.03.30       | NEW ISSUE   |                        |
| B                | 03.10.20       | ADD D6102-005/-007/-009                                   |                        |
| C                | 04.08.25       | ADD D6102-010/-011  |                        |
| D                | 06.06.30       | ADD D6102-013   |                        |

## SPECIFICATION CONTROL DRAWING



RELEASED

06.08.15 #

PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, LENGTH x WIDTH x THICK (+0.06/-0.00), AND GRAIN DIRECTION AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.06/-0.00.

ALL DIMENSIONS ARE IN INCHES.

| Part No.  | Alloy                                    | Length | Width  | Thick | Grain Direction     |
|-----------|--|--------|--------|-------|---------------------|
| D6102-001 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 7.880  | 6.250  | 2.000 | Along 7.880 Length  |
| D6102-003 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 6.000  | 6.250  | 2.000 | Along 6.000 Length  |
| D6102-005 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 47.85  | 15.250 | 1.000 | Along 47.85 Length  |
| D6102-007 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 7.500  | 7.000  | 2.500 | Along 7.500 Length  |
| D6102-009 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 11.000 | 6.000  | 5.000 | Along 11.000 Length |
| D6102-010 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 7.950  | 8.250  | 2.500 | Along 7.950 Length  |
| D6102-011 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 6.500  | 8.250  | 2.500 | Along 6.500 Length  |
| D6102-013 | 6061-T6/T651 (QQ-A-250/11 or QQ-A-200/8) | 6.500  | 7.000  | 2.000 | Along 6.500 Length  |

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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**Castle Metals®**

## PACKING SLIP

A. M. Castle &amp; Co.

Page 1 of 1

Shipment No:1230183

|  |                         |  |  |   |  |  |  |
|--|-------------------------|--|--|---|--|--|--|
| <b>Ship From:</b><br>A. M. Castle & Co. (Canada)<br>Inc.<br>MONTREAL<br>835-SELKIRK AVENUE<br>POINTE CLAIRE, QUEBEC<br>H9R 3S2 |                         | <b>Sold To:</b><br>DART AEROSPACE LTD<br>1270 ABERDEEN<br>HAWKESBURY, ON K6A 1K7<br>CA |  | <b>Ship To:</b><br>DART AEROSPACE LTD<br>1270 ABERDEEN<br>HAWKESBURY, ON K6A<br>1K7 CAN |  | <b>Deliver To:</b><br>DART AEROSPACE LTD<br>1270 ABERDEEN<br>HAWKESBURY, ON<br>K6A 1K7<br>CA |  |
| <b>Date Shipped</b><br>14-MAR-2012   | <b>F.O.B.</b><br>ORIGIN | <b>Freight Terms</b><br>Prepaid  |  | <b>Carrier</b><br>LOCAL FLEET   |  | <b>BOL No</b><br>1230183-4   |  |

|                         |                                       |
|-------------------------|---------------------------------------|
| <b>Shipment Details</b> | <b>Final Destination Branch - MON</b> |
|-------------------------|---------------------------------------|

|                                   |                     |  |   |                                 |                   |                                 |                                   |
|-----------------------------------|---------------------|--|---|---------------------------------|-------------------|---------------------------------|-----------------------------------|
| <b>Order No</b><br>2055827        | <b>Line No</b><br>1 | <b>Item No</b><br>8641.MO                            | <b>Description</b><br>2.0000.PL.6061.T651.ALUMINUM.48.5000.144.5000<br>CUT 2SIDED TO 7 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG<br>6.5")) X 6.5 IN ( + .0310/- .0000 IN (GRAIN TO RUN ALONG 6.5")) -<br>ALUMINUM PLATE SAW SPECIFICATIONS: QQ-A-250/11 |                                 |                   |                                 |                                   |
| <b>Purchase Order No</b><br>16358 |                     | <b>Part Number</b><br>YOUR ITEM NUMBER:<br>D6102-013 |   | <b>Ordered Qty</b><br>24.00 PCS |                   | <b>Invoice Qty</b><br>24.00 PCS |                                   |
| <b>Details</b>                    |                     |  |   |                                 |                   |                                 |                                   |
| <b>Delivery No.</b><br>117438219  | <b>Mill</b>         | <b>Heat Number</b><br>573889A3                       | <b>Mech Id</b>  | <b>PCS</b><br>24                | <b>Width (IN)</b> | <b>Length (IN)</b>              | <b>Shipped Qty(LBS)</b><br>218.74 |

|   |             |
|---|-------------|
| These commodities/technologies are subject to US Export Administration & US State Dept. Regulations and, if intended for export, were/are exported thereunder. Diversion contrary to US Law is Prohibited.  |             |
| We hereby certify the material covered by this certification conforms in accordance with the above specifications and has been found to meet the applicable requirements for the material, including any specifications forming a part of the description. Test reports are on file subject to examination. All claims for defective material are waived unless made in writing to A.M. Castle & Co. within 60 days of the shipment. Material cut to the correct size, or material cut by the customer cannot be returned for credit. |             |
| Reviewed by Authorized Castle Metals Representative:  | Date: Name: |

|  |
|--|
| <b>SHIP TO:</b><br>CASTLE METALS AEROSPACE<br>20826 68TH AVENUE, SOUTH<br>KENT, WA 98032             |
| <b>SOLD TO:</b><br>AM CASTLE & CO- SOLD TO<br>1420 KENSINGTON RD<br>SUITE 220<br>OAK BROOK, IL 60523 |

# KAISER ALUMINUM

Trentwood Works - Spokane, WA 99215  
 Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number  
 4250449



|                               |                         |                           |                     |  |                              |   |                       |                        |  |
|-------------------------------|-------------------------|---------------------------|---------------------|--|------------------------------|---|-----------------------|------------------------|--|
| CUSTOMER PO NUMBER:<br>143468 |                         | WORK PACKAGE:             |                     | CUSTOMER PART NUMBER:<br>8641 AMC A96061-161 R 2 |                              | SHIP RUN/LOAD:<br>102217/5                            |                       | GOV'T CONTRACT NUMBER: |  |
| KAISER ORDER NO:<br>1127390   | LINE ITEM:<br>1         | SHIP DATE:<br>10-JAN-2012 | ALLOY:<br>6061      | CLAD:<br>BARE                                    | TEMPER:<br>T651              | PRODUCT DESCRIPTION:<br>KaiserSelect® Precision Plate |                       |                        |  |
| WEIGHT SHIPPED:<br>5602 LB    | QUANTITY:<br>4 PCS EST. | B/L NUMBER:<br>2035222    | GAUGE:<br>2.0000 IN |  | DIAMETER/WIDTH:<br>48.500 IN |   | LENGTH:<br>144.500 IN |                        |  |

MHU 1554755: LOT 573981A8: 1 pieces;

MHU 1554768: LOT 573889A3: 3 pieces;

### Certified Specifications

AMS 4027/RevN

ASME SB 209/Rev2004

ASTM B 209/Rev10

Test Code: 1511

### Test Results

Lot: 573889A3 Cast 845 Drop 11 Ingot 1 Melted in USA

(ASTM E8/B557)

(EN 2002-1)

|          |        |                  |                            |                            |              |
|----------|--------|------------------|----------------------------|----------------------------|--------------|
| Tensile: | Temper | Dir / # Tests    | Ultimate KSI (MPA)         | Yield KSI (MPA)            | Elongation % |
|          | T651   | LT / 2 (Min:Max) | 49.4 : 50.6<br>(341 : 349) | 45.3 : 46.1<br>(312 : 318) | 13.9 : 14.1  |

(ASTM E1251)

|            |      |     |      |      |     |      |      |      |      |      |          |
|------------|------|-----|------|------|-----|------|------|------|------|------|----------|
| Chemistry: | SI   | FE  | CU   | MN   | MG  | CR   | ZN   | TI   | V    | ZR   | OTHER    |
| Actual     | 0.71 | 0.5 | 0.33 | 0.08 | 1.0 | 0.18 | 0.19 | 0.02 | 0.01 | 0.00 | TOT 0.04 |

Lot: 573981A8 Cast 845 Drop 19 Ingot 3 Melted in USA

(ASTM E8/B557)

(EN 2002-1)

|          |        |                  |                            |                            |              |
|----------|--------|------------------|----------------------------|----------------------------|--------------|
| Tensile: | Temper | Dir / # Tests    | Ultimate KSI (MPA)         | Yield KSI (MPA)            | Elongation % |
|          | T651   | LT / 2 (Min:Max) | 49.1 : 50.6<br>(339 : 349) | 44.1 : 46.0<br>(304 : 317) | 14.0 : 14.9  |

(ASTM E1251)

|            |      |     |      |      |     |      |      |      |      |      |          |
|------------|------|-----|------|------|-----|------|------|------|------|------|----------|
| Chemistry: | SI   | FE  | CU   | MN   | MG  | CR   | ZN   | TI   | V    | ZR   | OTHER    |
| Actual     | 0.71 | 0.5 | 0.33 | 0.05 | 1.0 | 0.18 | 0.22 | 0.01 | 0.01 | 0.00 | TOT 0.04 |



Trentwood Works - Spokane, WA 99215

Phone: (800) 367-2586

## CERTIFIED TEST REPORT

Serial Number

4250449

## ALLOY LIMITS

|      | SI   | FE  | CU   | MN   | MG  | CR   | ZN   | TI   | V    | ZR   | OTHER | MAX  |
|------|------|-----|------|------|-----|------|------|------|------|------|-------|------|
| 6061 |      |     |      |      |     |      |      |      |      |      |       |      |
| MIN  | 0.40 | 0.0 | 0.15 | 0.00 | 0.8 | 0.04 | 0.00 | 0.00 | 0.00 | 0.00 | EACH  | 0.05 |
| MAX  | 0.8  | 0.7 | 0.40 | 0.15 | 1.2 | 0.35 | 0.25 | 0.15 | 0.05 | 0.05 | TOT   | 0.15 |

Aluminum Remainder

## TEST NOTES

6061 sheet or plate certified to AMS 4025, AMS 4026, or AMS

4027 also meets applicable requirements of AMS-QQ-A-250/11

Rev.A.

## CERTIFICATION

KAISER ALUMINUM FABRICATED PRODUCTS, LLC (KAISER) HEREBY CERTIFIES THAT METAL SHIPPED UNDER THIS ORDER WAS MELTED IN THE UNITED STATES OF AMERICA OR A QUALIFYING COUNTRY PER DFARS 226.872-1(a), WAS MANUFACTURED IN THE UNITED STATES OF AMERICA AND MEETS THE REQUIREMENTS OF DFARS 252.225 FOR DOMESTIC CONTENT. THIS MATERIAL HAS BEEN INSPECTED, TESTED, AND FOUND IN CONFORMANCE WITH THE REQUIREMENTS OF THE APPLICABLE SPECIFICATIONS AS INDICATED HEREIN. ALL METAL WHICH IS SOLUTION HEAT TREATED COMPLIES WITH AMS 2772. ANY WARRANTY IS LIMITED TO THAT SHOWN ON KAISER'S STANDARD GENERAL TERMS AND CONDITIONS OF SALE. TEST REPORTS SHALL NOT BE REPRODUCED EXCEPT IN FULL, WITHOUT THE WRITTEN APPROVAL OF KAISER ALUMINUM FABRICATED PRODUCTS, LLC LABORATORY. THE RECORDING OF FALSE, FICTITIOUS, OR FRAUDULENT STATEMENTS OR ENTIRE ON THE CERTIFICATE MAY BE PUNISHED AS A FELONY UNDER FEDERAL LAW. ISO-9001:2000 CERTIFIED.

MIKE KLOCKE, LABORATORIES SUPERVISOR